

Date: Monday, 22/09/2008 2:00:49 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY  
 Job Number : 42192  
 Estimate Number : 10280  
 P.O. Number :  
 This Issue : 22/09/2008 S.O. No. :  
 Prsht Rev. : NC Drawing Number : D3137-REV E  
 First Issue : / / Type : MACHINED PARTS Project Number : N/A  
 Previous Run : 31730 Drawing Revision : F  
 Material :  
 Due Date : 25/10/2008 Qty: 50 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: A 04.02.18 New issue KJ/DS  
 Est Rev B 08.07.03 ECN1207 EC verified by DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M174B0500X02000 17-4 SS Bar .500 x 2.00



Comment: Qty.: 0.4875 f(s)/Unit Total: 24.3758 f(s)  
 Material: 17-4 SS Bar per AMS 5604/5643  
 (M17-4-B0.500x02.000)  
 Identify for D3137-7  
 Batch: 714932

50

2.0 BAND SAW BAND SAW



50

Comment: BAND SAW

Cut blanks: (.500" x 2.000") 5.570" long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3137-7 as per Folio FA3300 and Dwg D3137 Identify as D3137-7

2-Deburr

3-Scribe batch number

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Ensure C of C attached Pp/12/1 (40)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 22/09/2008 2:00:49 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 42192

Part Number: D3137043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

SECOND CHECK



46

Comment: SECOND CHECK

Inspect levels

08-12-01

QSP019

6.0

D31373

Guide



46

Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3137-3

GUIDE

39449

SS 08/12/02 (46)

7.0

D31375

Washer



46

Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3137-5

Washer

B37881 x10 B42270 x36

SS 08/12/02 x46

8.0

MS24694S101

Screw



46

Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS24694-s101

Screw

M103338

SS 08/12/02 (46)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble D3137-043 as per Dwg D3137

EP 08/12/02 (46)

10.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

S 08/12/02 (46)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57238

SS 08/12/03 (46)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 22/09/2008 2:00:49 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 42192

Part Number: D3137043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*mf 08-12-03*

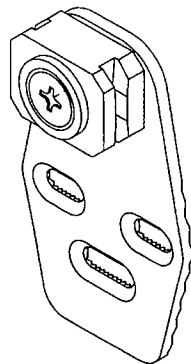
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |  |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr |  | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |  |                          |
|      |      |                    |    |      |     |                                     |  |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

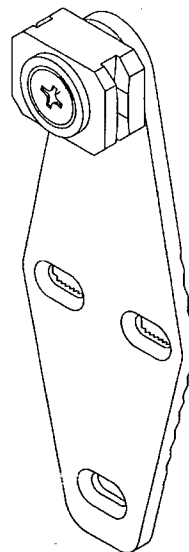
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |           |              |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------|--------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval  |              |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           | Chief Eng | QC Inspector |
|      |      |                                  |                                |                                 |                |                           |           |              |
|      |      |                                  |                                |                                 |                |                           |           |              |
|      |      |                                  |                                |                                 |                |                           |           |              |

**NOTE:** Date & initial all entries

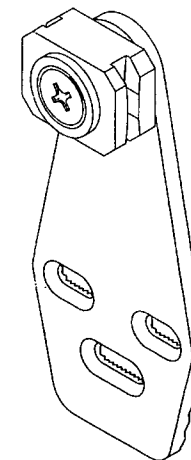


**D3137-041 BRACKET ASSEMBLY**



**D3137-043 BRACKET ASSEMBLY**

*W/022192*

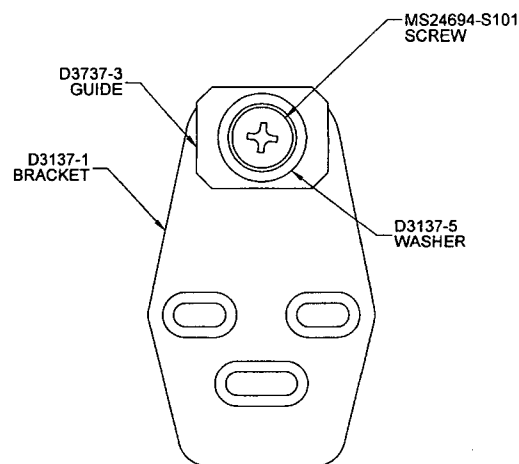


**D3137-045 BRACKET ASSEMBLY**

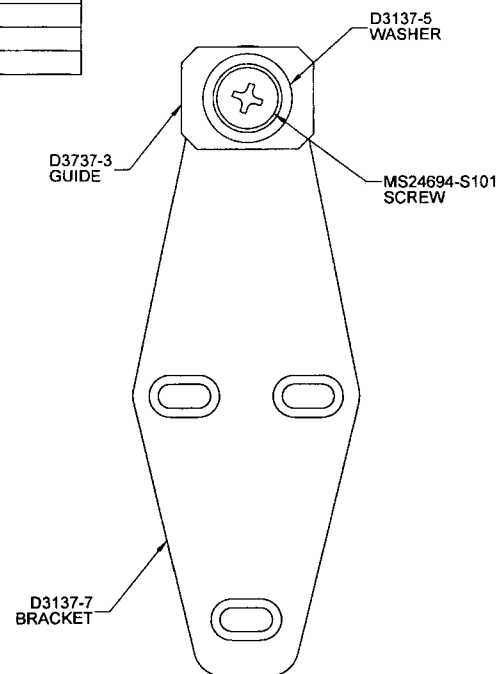
**RELEASE**  
08-06-2017

|            |  |   |              |
|------------|--|---|--------------|
| F          | REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3<br>ZONE A 5 DIM 2.36 WAS 2.48, ZONE A 4 0.430 DIM WAS<br>0.605, ZONE A 8 0.67 DIM WAS 0.79, ZONE B 5 4.850 DIM<br>WAS 4.975 & ZONE B 8 5.29 DIM WAS 5.41. REASON: PART<br>TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE<br>INTERIOR. | AJS   | 08.05.30     |
| E          | ADD -045   | RF  | 05.11.23     |
| D          | RE-DESIGN D3137-5; CHANGE DIMS   | DS  | 04.11.03     |
| C          | ADD -043   | DS  | 03.08.15     |
| B          | ADD RIDGES; ADD MATERIAL PROP  | DS  | 03.01.16     |
| A          | NEW ISSUE  | DS  | 02.04.17     |
| REV.       | DESCRIPTION  | BY  | DATE         |
| DESIGN     | DS   | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      | AJS  | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    |  | DRAWING NO.   | REV. F       |
| MFG. APPR. |  | D3137   | SHEET 1 OF 5 |
| APPROVED   |  | TITLE   | SCALE        |
| DE APPR.   |  | <b>BRACKET ASSEMBLY</b>   | NTS          |
| DATE       | 08.05.30   | <small>COPYRIGHT © 2002 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> |              |

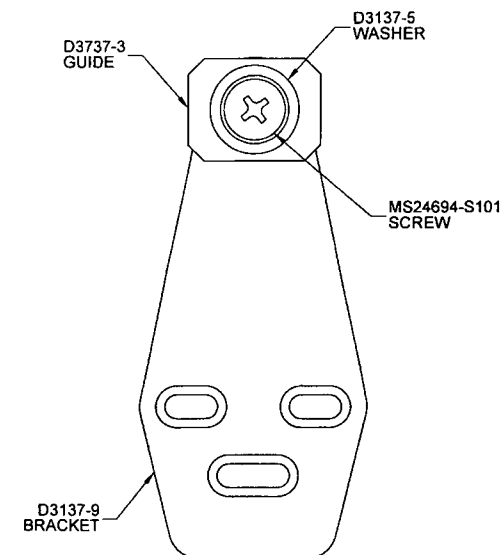
| QTY.<br>-041 | QTY.<br>-043 | QTY.<br>-045 | PART NUMBER  | DESCRIPTION      |
|--------------|--------------|--------------|--------------|------------------|
| X            |              |              | D3137-041    | BRACKET ASSEMBLY |
|              | X            |              | D3137-043    | BRACKET ASSEMBLY |
|              |              | X            | D3137-045    | BRACKET ASSEMBLY |
| 1            |              |              | D3137-1      | BRACKET          |
| 1            | 1            | 1            | D3137-3      | GUIDE            |
| 1            | 1            | 1            | D3137-5      | WASHER           |
|              | 1            |              | D3137-7      | BRACKET          |
|              |              | 1            | D3137-9      | BRACKET          |
| 1            | 1            | 1            | MS24694-S101 | SCREW            |



**D3137-041 BRACKET ASSEMBLY**



**D3137-043 BRACKET ASSEMBLY**



**D3137-045 BRACKET ASSEMBLY**

**NOTES:**

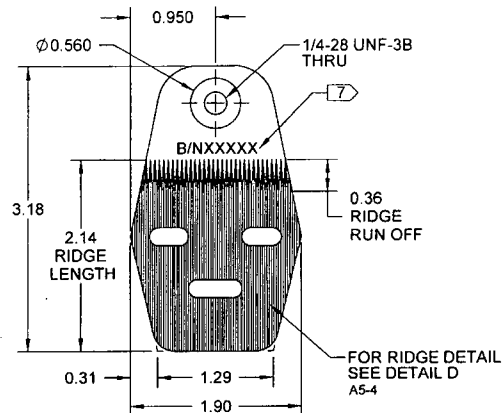
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041  
0.32 lbs -043  
0.27 lbs -045

*Mo 42192*

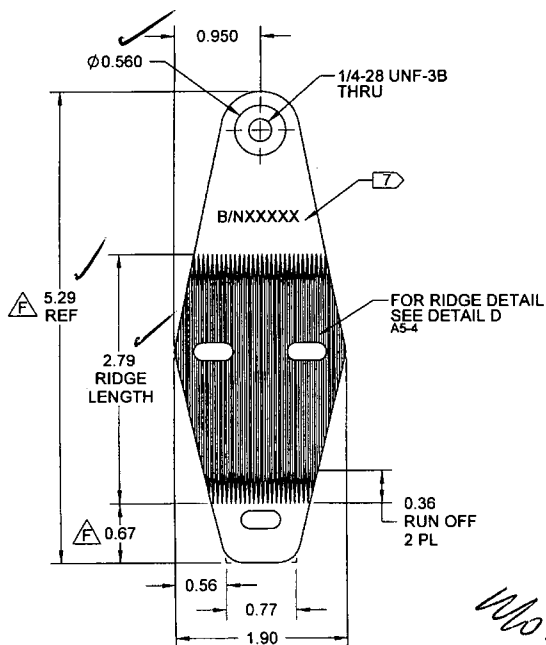
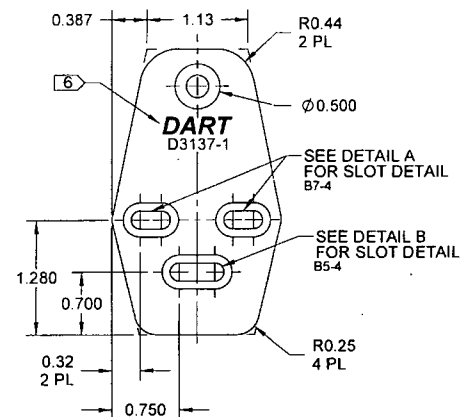
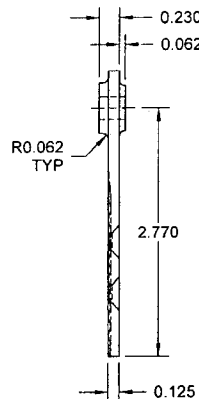
**RELEASED**  
08-06-26/11

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | DS       | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      | AJS      | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    |          | DRAWING NO. <b>D3137</b>  | REV. F       |
| MFG. APPR. |          |   | SHEET 2 OF 5 |
| APPROVED   |          | TITLE   | SCALE        |
| DE APPR.   |          | <b>BRACKET ASSEMBLY</b>   | NTS          |
| DATE       | 08.05.30 | COPYRIGHT © 2002 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD |              |

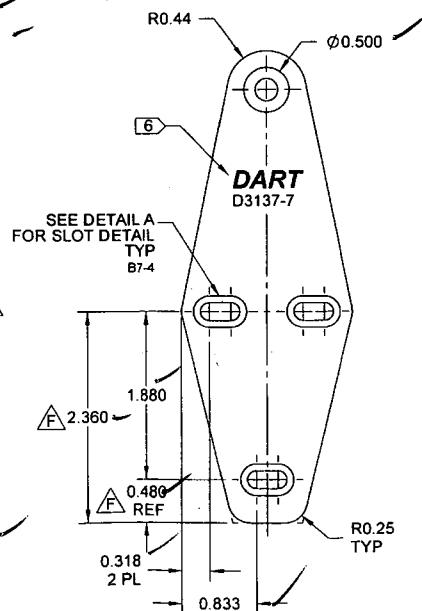
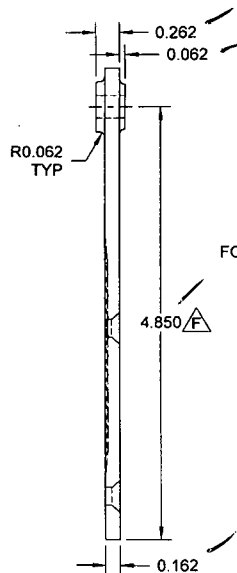




**D3137-1 BRACKET**



**D3137-7 BRACKET**

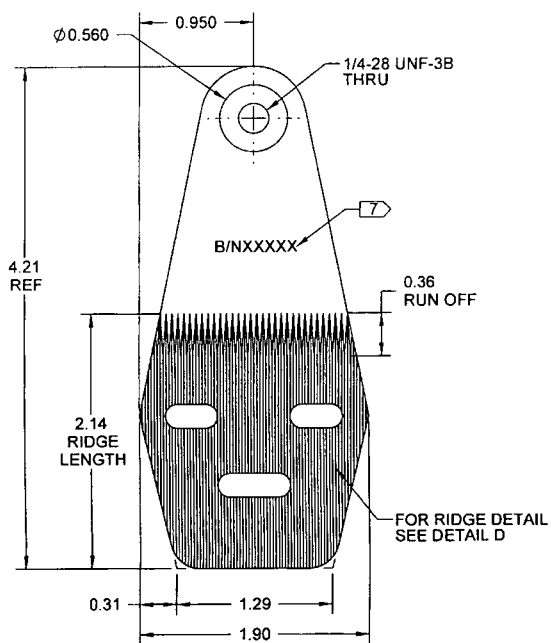


**NOTES:**

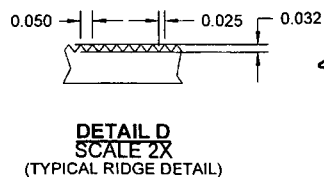
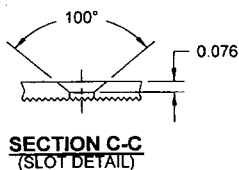
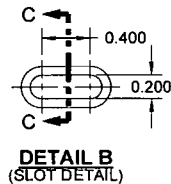
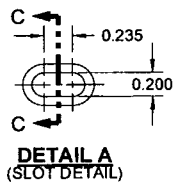
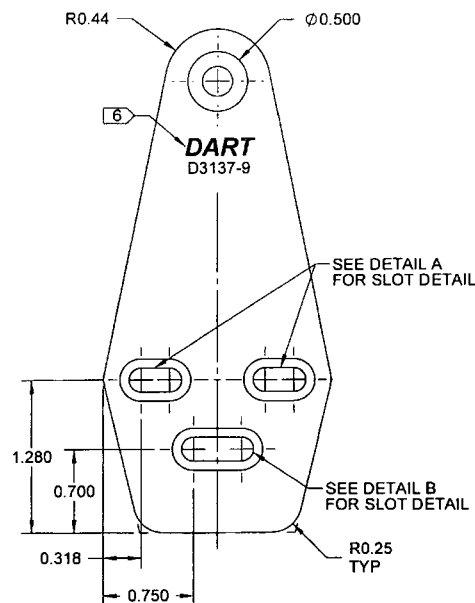
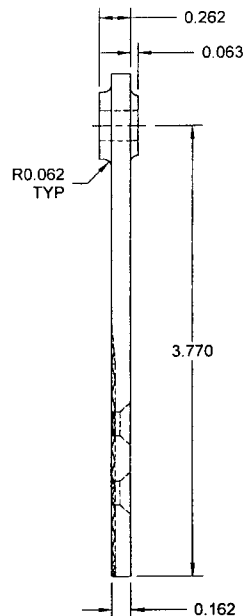
- 1) MATERIAL: -1 & -7  
17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi  
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) -1 REPLACES PREMIER P/N B30-23000-105/-1

**RELEASED**  
08-06-26

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | DS       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |              |
| DRAWN      | AJS      |   |              |
| CHECKED    |          | DRAWING NO.   | REV. F       |
| MFG. APPR. |          | <b>D3137</b>  | SHEET 3 OF 5 |
| APPROVED   |          | TITLE   | SCALE        |
| DE APPR.   |          | <b>BRACKET ASSEMBLY</b>   | NTS          |
| DATE       | 08.05.30 | COPYRIGHT © 2002 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD |              |



**D3137-9 BRACKET**

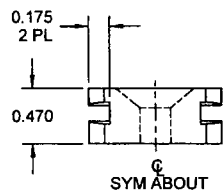
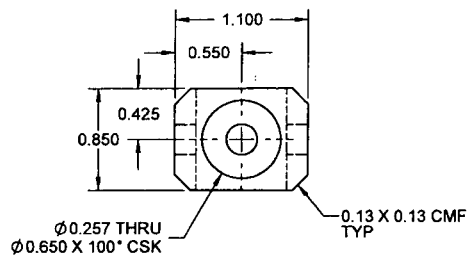


- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi  
PER DART SPEC. M17-4-B
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
  - 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
  - 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
  - 9) REPLACES PREMIER P/N B30-23000-105/-106

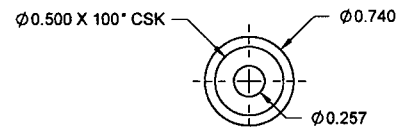
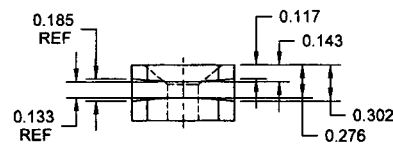
|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | DS       | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      | AJS      | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    |          | DRAWING NO.   | REV. F       |
| MFG. APPR. |          | D3137   | SHEET 4 OF 5 |
| APPROVED   |          | TITLE   | SCALE        |
| DE APPR.   |          | <b>BRACKET ASSEMBLY</b>   | NTS          |
| DATE       | 08.05.30 | <small>COPYRIGHT © 2002 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> |              |

**RELEASED**  
08.06.36

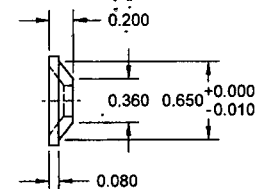
*W042192*



**D3137-3 GUIDE**



**D3137-5 WASHER**



**NOTES:**

- 1) MATERIAL: -3  
DELIN II 150E OR ACETRON GP ACETAL, BAR  
(REF DART SPEC M-DELIN-B)  
-5  
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR  
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)  
OR PER-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207  
-5 REPLACES PREMIER P/N B30-2300-209

**RELEASED**

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | DS       | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | AJS      | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |          | DRAWING NO.  | REV. F       |
| MFG. APPR. |          | D3137  | SHEET 5 OF 5 |
| APPROVED   |          | TITLE  | SCALE        |
| DE APPR.   |          | BRACKET ASSEMBLY   | NTS          |
| DATE       | 08.05.30 | <small>COPYRIGHT © 2002 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |

*Wb 42192*





# Invoice

36 Colonnade Road N.  
Ottawa, Ontario K2E 7J6  
Tel: (613) 226-1579  
Fax: (613) 226-1719

| DATE       | INVOICE NO. |
|------------|-------------|
| 11/27/2008 | 17362       |

|   |  |                  |   |                |            |
|---|--|------------------|---|----------------|------------|
| <b>BILL TO</b>  |  |                  | <b>SHIP TO</b>  |                |            |
| Dart Aerospace<br>1270 Aberdeen Street<br>Hawksbury, Ontario<br>K6A 1K7 |  |                  | Main Finished Goods Location<br>Dart Aerospace<br>1270 Aberdeen Street<br>Hawksbury, Ontario<br>K6A 1K7 |                |            |
| <b>P.O. NO.</b>   | <b>TERMS</b>   | <b>SHIP DATE</b> | <b>SHIPPED VIA</b>  | <b>JOB NO.</b> | <b>FOB</b> |
| 00007241  | Net 30 Days  | 11/27/2008       | FedEx   | 812            | Globus     |
| <b>QTY</b>  | <b>DESCRIPTION</b>   |                  |   |                |            |
| 46  | D3137043 Bracket Assembly<br><br>Business Number: 102122058<br><br><div style="text-align: center;">WE CERTIFY THAT ITEMS LISTED HAVE BEEN<br/>MANUFACTURED IN ACCORDANCE WITH DRAWINGS<br/>AND PURCHASE ORDER SPECIFICATIONS<br/><br/><i>AR</i></div> |                  |   |                |            |

WHITE = Original  
BLUE = C of C  
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum  
on Overdue Accounts



# Invoice

36 Colonnade Road N.  
Ottawa, Ontario K2E 7J6  
Tel: (613) 226-1579  
Fax: (613) 226-1719

| DATE       | INVOICE NO. |
|------------|-------------|
| 11/27/2008 | 17362       |

|   |  |            |   |         |        |
|---|--|------------|---|---------|--------|
| BILL TO   |  |            | SHIP TO   |         |        |
| Dart Aerospace<br>1270 Aberdeen Street<br>Hawksbury, Ontario<br>K6A 1K7 |  |            | Main Finished Goods Location<br>Dart Aerospace<br>1270 Aberdeen Street<br>Hawksbury, Ontario<br>K6A 1K7 |         |        |
| P.O. NO.  | TERMS  | SHIP DATE  | SHIPPED VIA   | JOB NO. | FOB    |
| 00007241  | Net 30 Days  | 11/27/2008 | FedEx   | 812     | Globus |
| QTY   | DESCRIPTION  |            |   |         |        |
| ✓ 46  | D3137043 Bracket Assembly<br><br>Business Number: 102122058<br><br><i>10/28/01</i> |            |   |         |        |

WHITE = Original  
BLUE = C of C  
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum  
on Overdue Accounts